

AMENDMENTS TO THE CLAIMS:

The listing of claims will replace all prior versions, and listings, of claims in the application:

1-4. (Canceled)

5. (Currently Amended) Gravure printing process for a multi-stand gravure printing machine including a first printing unit containing an impression roller and a driven print cylinder, and at least one additional printing unit, each additional printing unit including an impression roller and a driven print cylinder, the process comprising the steps of:

actively driving the impression roller of the at least one additional printing unit,

actively driving the print cylinder of the at least one additional printing unit, and

regulating the web tension of a web by a drive of the impression roller of the at least one additional printing unit.

6. (Currently Amended) Gravure printing process ~~of claim 5,~~ further for a multi-stand gravure printing machine including a first printing unit containing an impression roller and a driven print cylinder, and at least one additional printing unit, each additional printing unit including an impression roller and a

driven print cylinder, the process comprising the steps of:

actively driving the impression roller of the at least one additional printing unit,

regulating the web tension of a web by a drive of the impression roller of the at least one additional printing unit,

setting the web velocity, upon start-up of the gravure printing machine, when the print cylinders are brought to a uniform, regulated rotational speed, by a draw-in mechanism, and regulating the rotational speed of each driven impression roller such that a uniform web tension results in all printing units.

7. (Previously Presented) Gravure printing process of claim 5, further comprising the steps of:

setting the web velocity, upon start-up, of the impression roller of the printing unit adjacent to a draw-in mechanism, and

regulating the rotational speed of a draw-in mechanism and impression roller of the at least one additional printing unit, so that a uniform web tension results.

8. (Previously Presented) Gravure printing process of claim 5, further comprising the step of:

regulating, during start-up, the rotational speed of

the print cylinder in the at least one additional printing unit by an optical sensor so that register accuracy is achieved.

9. (Currently Amended) Gravure printing process ~~of claim 5,~~ further for a multi-stand gravure printing machine including a first printing unit containing an impression roller and a driven print cylinder, and at least one additional printing unit, each additional printing unit including an impression roller and a driven print cylinder, the process comprising the steps of:

actively driving the impression roller of the at least one additional printing unit,

regulating the web tension of a web by a drive of the impression roller of the at least one additional printing unit,

sustaining, during a run time, the rotational speeds of the impression rollers attained in ~~the~~ a start-up, and

making a reaction to departures from a uniform web tension with brief variations of a set speed of a driven impression roller from the rotational speed reached during start-up.

10. (Previously Presented) Gravure printing process of claim 5, further comprising the steps of:

sustaining, during a run time, the speeds of the print cylinders reached during start-up, and

making a reaction to register errors with brief departures of a set speed from the speed reached during start-up.

11. (Previously Presented) Gravure printing process of claim 9, wherein the step of making a reaction to departures to produce the brief variations of the set speed of a driven impression roller includes the step of establishing an advance or retardation with respect to another impression roller at the drive of the other impression roller.

12. (Previously Presented) Gravure printing process of claim 10, wherein the step of making a reaction to produce the brief departure of the set speed of a print cylinder includes the step of establishing an advance or retardation, with respect to another print cylinder at the drive of the other print cylinder.